

29

Date: Friday, 5/25/2007 12:51:40 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 32682		
Estimate Number	: 10257		
P.O. Number	:	Part Number	: D212664201
This Issue	: 5/25/2007 S.O. No. :	Drawing Number	: D212-664-241 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 32681	Material	:
Written By	:	Due Date	: 7/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.05.28</u>		
Comment	: Est Rev: 04.02.16 Reformat K/DS : Est Rev: F 06-03-29 Remove Coments on Pick List JLM : Est Rev: G 07-04-30 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

07.06.14
07/07/02

2.0	D6006129	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube *B25666*

Check OD = 3.250"; ID = 2.220"

07/07/02

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

07/07/02

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

07/02/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

JS 07/07/05

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JS 07/07/05

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07-01-10

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

ML 07/07/05

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JD 7-7-12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/07/05 (XL)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

JD 7-7-12

W/O:		WORK ORDER CHANGES					
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Job Number: 32682

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/25 (XL)

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

EL 7-7-25

14.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

En 07/08/22

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

25
07-08-22
JD 7-9-10

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

JD 7-9-10

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/09/11

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

checked all hls

En 07/09/11

19.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4568

LPI as per ASTM 1417 Level 2

07/09/11 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 32682

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/18

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

07-19-0

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 07-09-25 ①

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

25 07-09-27

P50

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

32780

25 07-09-27

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0242 sf(s)/Unit Total : 0.0242 sf(s)

Rubber Cushion (per sq ft)

.63" x 5.300

Batch:

33834

25 07-09-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-201 PAR #: NA Fault Category: Prod / Finishing NCR: (Yes) No DQA: D Date: 07/10/04
 QA: N/C Closed: JA Date: 07.10.04

NCR: 32682		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070925	22.0	Paint was a little light on 2 sides of the tube	<u>JS/10/2</u>	sand and re-paint tube	<u>M</u> <u>070925</u>	<u>PT</u> <u>070927</u>	<u>JS/10/2</u>	<u>070925</u>

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Job Number: 32682

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

105385

25 07-09-27

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 104723

Expiry Date: 08-10-01

11:00 am 07-09-27

2-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

27 07-09-27

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/28

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch:

B26249-

31.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M104374-

07/09/280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32682

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100743

33.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M104745

34.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M104021

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32682
Description: Crosstube Assembly (205/212 High Aft)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: <i>EC</i> <i>05.28</i>		Page 1 of 1	

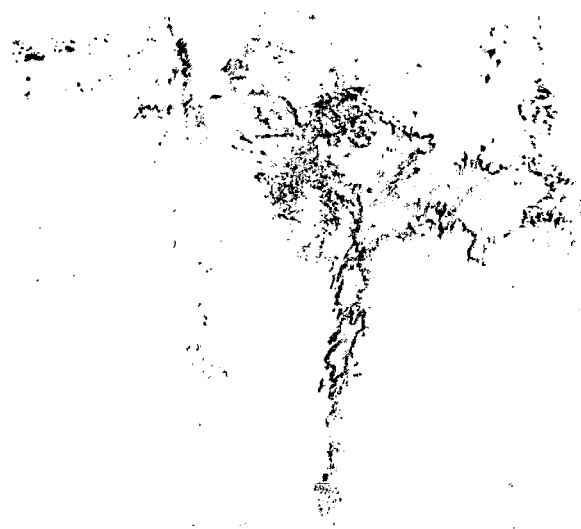
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200				
	R0.063	+/-0.010	0.063				
	2.990	+0.005/-0.000	2.993				
	5.237	+/-0.030	5.245				
	2.600	+0.005/-0.000	2.603				
	2.686	+0.005/-0.000	2.689				
	2.770	+0.005/-0.000	2.773				
	2.854	+0.005/-0.000	2.857				
	2.938	+0.005/-0.000	2.941				
	3.021	+0.005/-0.000	3.024				
	3.133	+0.005/-0.000	3.136				
	3.179	+0.005/-0.000	3.181				
SIDE B	0.200	+/-0.010	0.200				
	R0.063	+/-0.010	0.063				
	2.990	+0.005/-0.000	2.993				
	5.237	+/-0.030	5.245				
	2.600	+0.005/-0.000	2.603				
	2.686	+0.005/-0.000	2.689				
	2.770	+0.005/-0.000	2.773				
	2.854	+0.005/-0.000	2.857				
	2.938	+0.005/-0.000	2.941				
	3.021	+0.005/-0.000	3.024				
	3.133	+0.005/-0.000	3.137				
	3.179	+0.005/-0.000	3.181				
	124.36	+/-0.020	124.37				

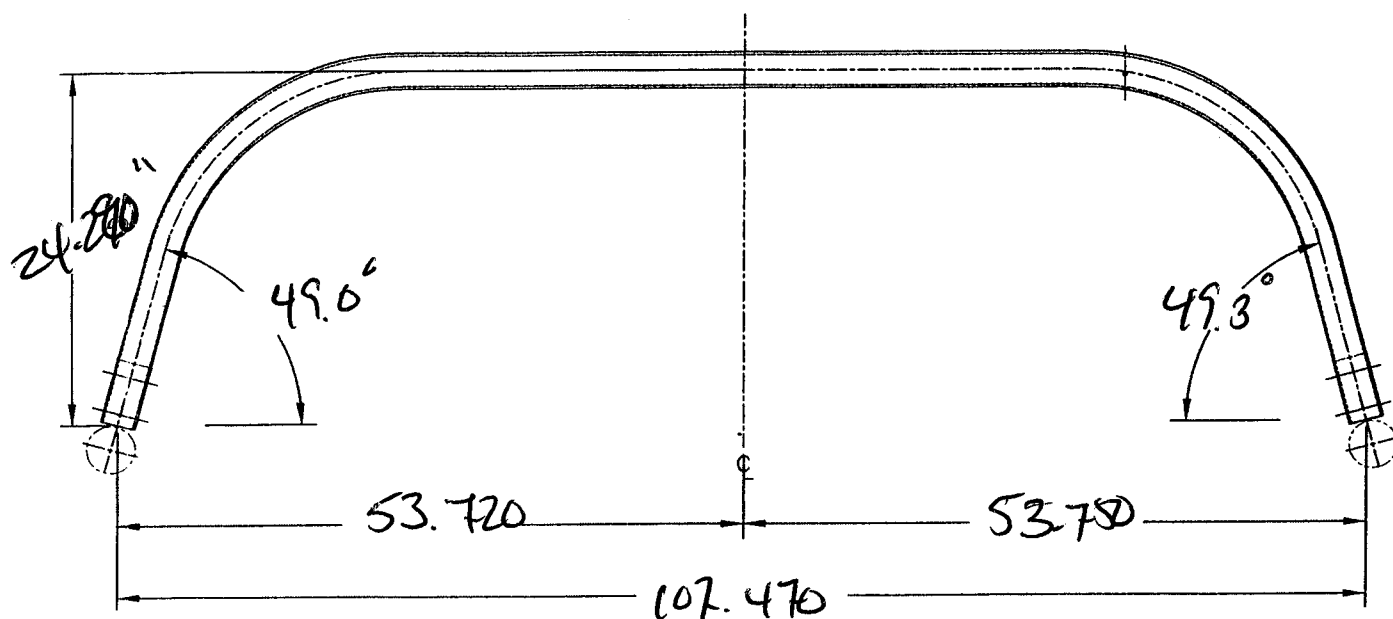
Measured by: <i>SB</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 07/06/30	Date: 07.07.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	



DART AEROSPACE LTD		Work Order:	32682
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	5/10/22
Date	5/10/22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	

DART**RELEASED**
07.04.24 P
PER E.C.N. 2859

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

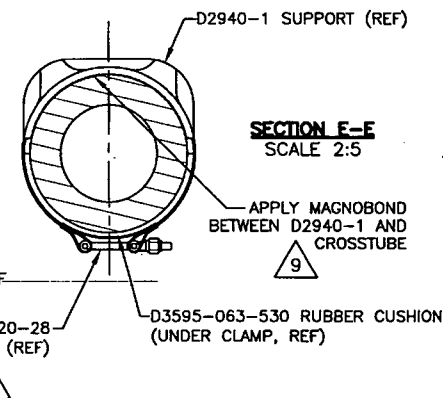
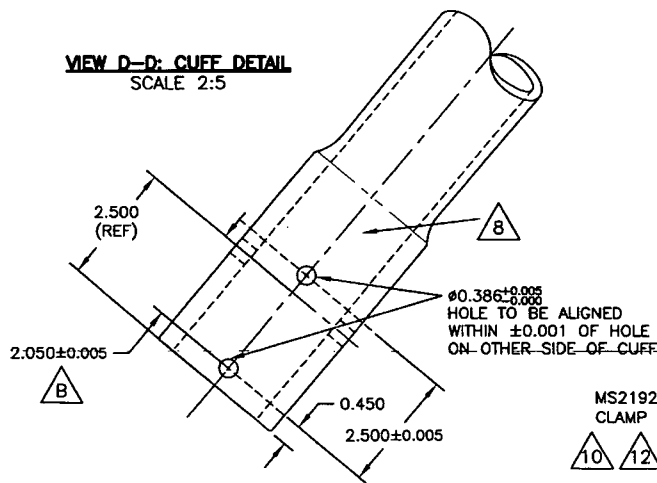
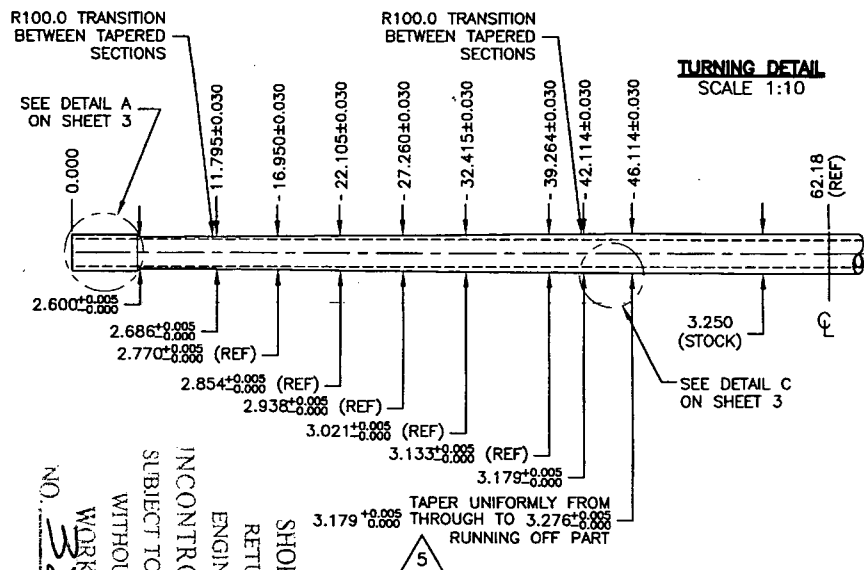
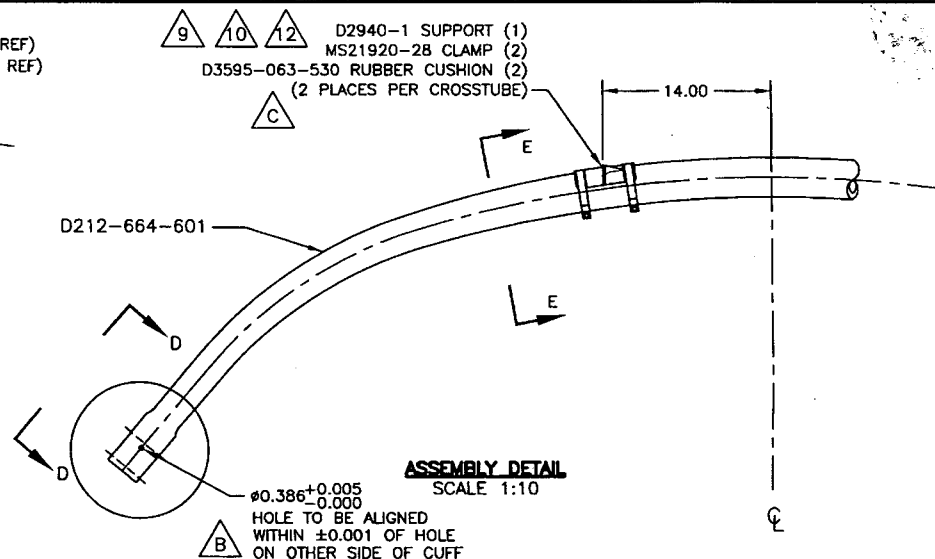
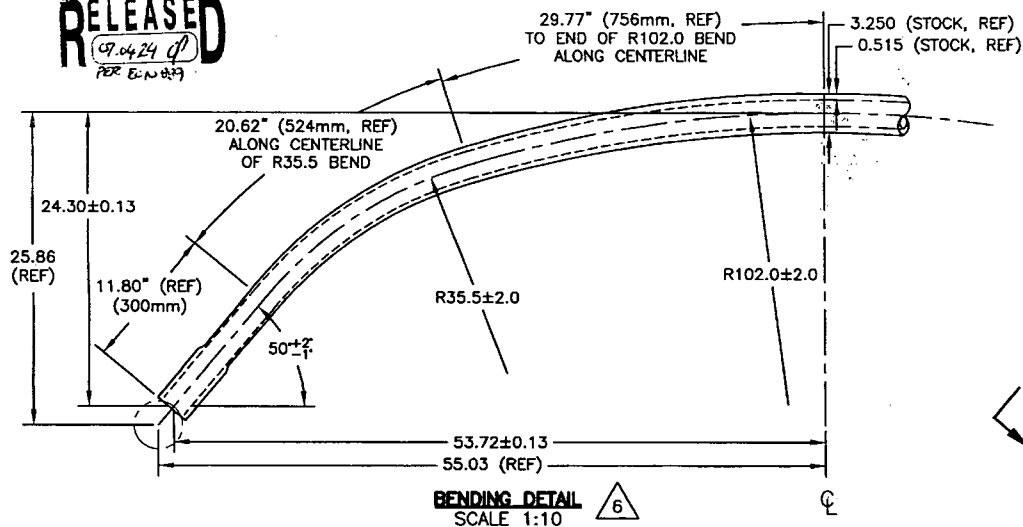
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WORK ORDER

NO. 32682

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DESIGN	
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DRAWN BY

CHECKED	
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APPROVED *h*

DATE
07.03.08

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO.
D212-664-241

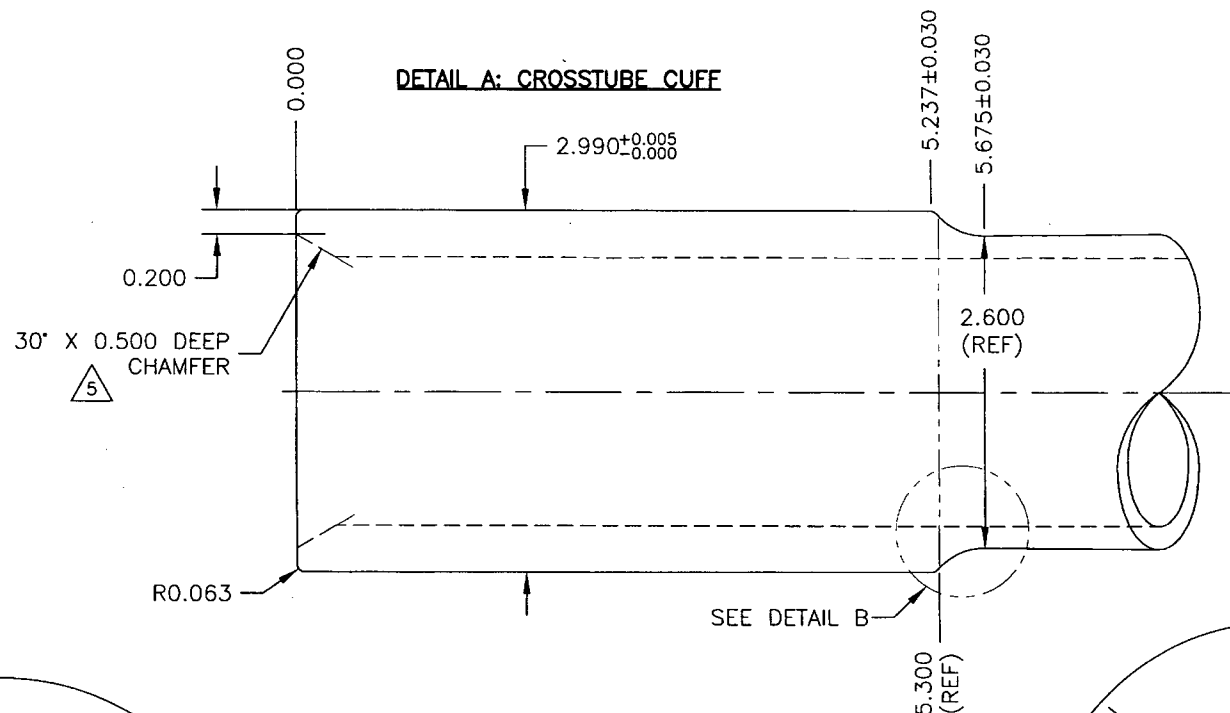
REV. C
SHEET 2 OF 3

TITLE	SCALE
CROSSTUBE ASS'Y (205/212 HI AFT)	1:10

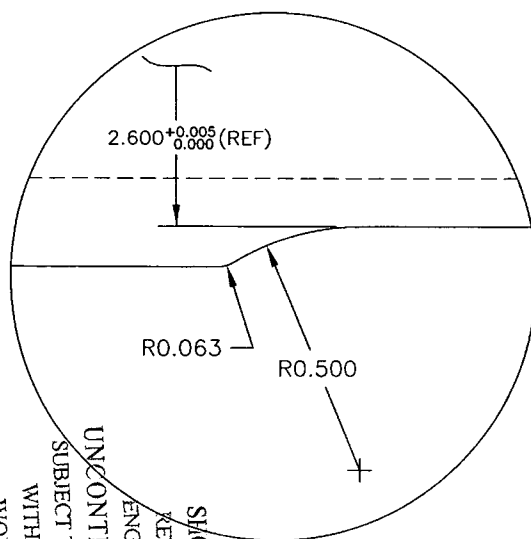
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NO. 32682

RELEASED
 07.04.24
 PER ECN 889

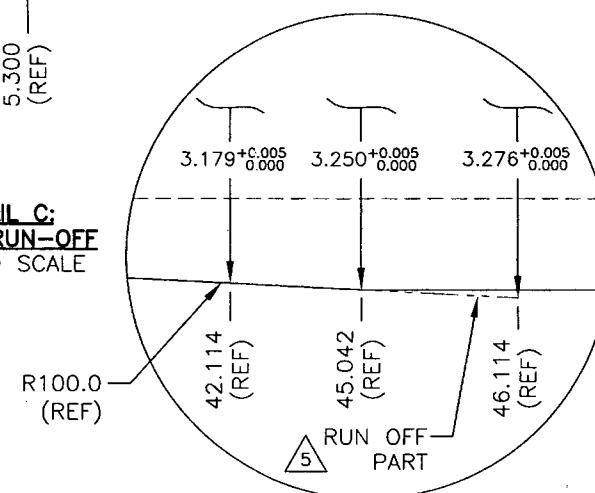
DETAIL A: CROSSTUBE CUFF



**DETAIL B: CUFF
TRANSITION**
 SCALE 4:1



**DETAIL C:
TAPER RUN-OFF**
 NOT TO SCALE



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 DART AEROSPACE LTD.

DESIGN
 PH
 CHECKED
 DATE
 07.03.08

DRAWN BY
 PH
 APPROVED
 [Signature]

DART DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
 D212-664-241

REV. C
 SHEET 3 OF 3

TITLE
 CROSSTUBE ASS'Y (205/212 HI AFT)

SCALE
 1:1

NO. 32882
 WORK ORDER
 RETURN TO
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 WITHOUT NOTICE

**HeathAir**

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37465

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT**AIRCRAFT / COMPONENT INFORMATION**

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (3) P/N D212-664-201 S/N's B32682, B32679 and B32683.

Qty (1) P/N D412-664-203 S/N B32230.

Qty (3) P/N D206-667-203 S/N's B34042, B34049 and B34048.

☐ RADIOGRAPHY☐ ULTRASONIC☒ PENETRANT☐ MAGNETIC PARTICLE☐ EDLY CURRENT**INSPECTION REPORT**

Fluorescent penetrant inspection was performed in accordance with the above requirements on (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(7) cross tubes inspected. (7) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE September 18, 2007

INSPECTION
STAMP(S) **CUSTOMER INFORMATION**

CUSTOMER: Dart Aerospace

P.O. NUMBER PO 00004568

ADDRESS:

CONTACT NAME: Linda Lacelle

LABOUR	Ⓢ	\$
MATERIALS	Ⓢ	
TRAVEL EXPENSES	Ⓢ	GST
HOTEL EXPENSES	Ⓢ	PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT